

Work Order ID 62565 - SCRAP



Page 1

Monday, October 04, 2010 1:11:51 PM

Item ID: D4093-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 10/5/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/18/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-10-04 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4093	A

110



Waterjet

FLOW CNC Waterjet

6661 .75 X 6.

Memo

CUT AS DWG

DWG REV: A

PROG REV: A

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

10-10-05

(2)

Scrap
Parts had very bad
finish

10-10-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62565

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Page 2

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Start Date: 10/5/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/18/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

S101005

0.00

130

QC8- Inspect parts - second check



QC

Quality Control

132



Small Fab

Memo

0.00

J.F.S. 10/10/22

(x2)

Small Fab

DRILL AS PER DWG

135



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S101005

0.00

(x2)

Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 62565

Page 3

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Cust Item ID:

Required Date: 10/18/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2 BL 10-10-28.

150



White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M15291. START 3:40
Memo QUIT 3:20
FINISH 4:10.

Powdercoat

Powder Coating

2 BL 10-11-1.

160



QC3- Inspect Part Finish

0.00

QC

Quality Control

Memo

0.00

2 10/11/02

2 f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 62565

Page 4

Monday, October 04, 2010 1:11:51 PM

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Start Date: 10/5/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/18/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



Identify as per dwg & Stock Location:

Packaging

Memo

PPP
62562
628~3

180



QC21- Final Inspection - Work Order Release

QC

Memo

Quality Control

0.00

0.00

Recept 10/04/2010

A. 10.11.09

10/04/10 JGD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/11/15		finish not acceptable 0.4.15		Scrap/destroy	SP 10/11/15 2X		11. 0.4.15	

NOTE: Date & initial all entries

Picklist Print

Page 1

Monday, October 04, 2010 1:11:50 PM

Work Order ID: 62565



Parent Item: D4093-1



Parent Item Name: Bracket

Start Date: 10/5/2010

Required Date: 10/18/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: Ipp Rev:A New Issue 10-05-31 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X06.00 0		Purchased	No			f		42.0800	1	2			

6061T6 BAR .750 X 6.00



P10-10-5

Location	Loc Qty	Loc Code
MAT03	42.08	
112567	42.08	112567

(2)

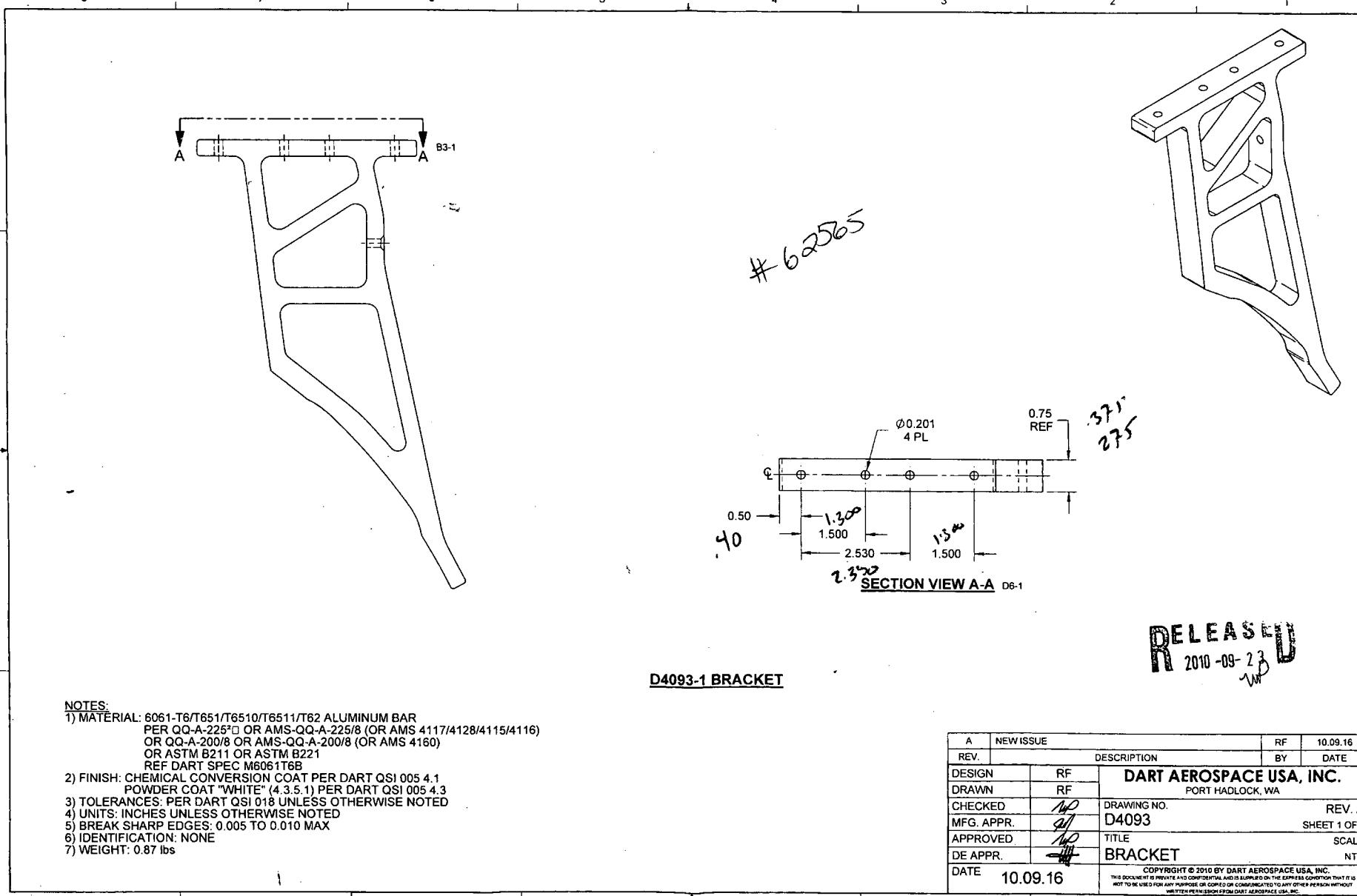
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



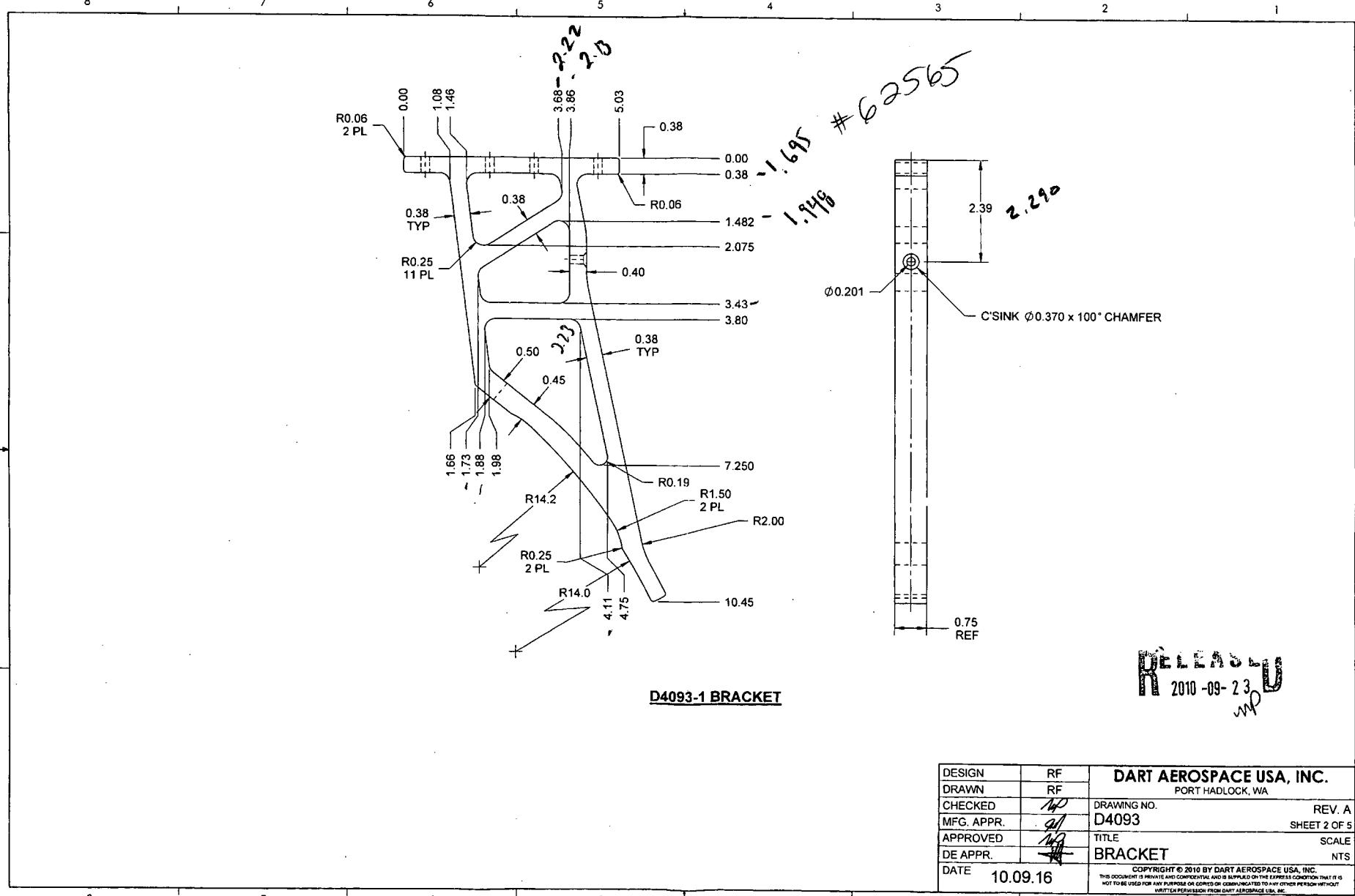
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	141	DRAWING NO.	
MFG. APPR.	SH	D4093	REV. A
APPROVED	142	TITLE	SHEET 2 OF 5
DE APPR.	142	BRACKET	SCALE
DATE	10.09.16	NTS	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	62565
Description: BRACKET	Part Number:	D4093-1
Inspection Dwg: D4093-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.08	+/- .030	1.083	X		V	HB02
1.46	+/- .030	1.460	X		V	
3.86	+/- .030	3.863	X		V	
5.03	+/- .030	5.027	X		V	
.38	+/- .030	.375	X		V	
1.482	+/- .010	1.480	X		V	
2.075	+/- .010	2.078	X		V	
.40	+/- .030	.410	X		V	
3.43	+/- .030	3.426	X		V	
3.80	+/- .030	3.801	X		V	
.38	+/- .030	.377	X		V	
.45	+/- .030	.461	X		V	
.50	+/- .030	.509	X		V	
7.250	+/- .00	7.247	X		V	
10.45	+/- .030	10.443	X		VPR6 HB02	
.75	+/- .030	.740	X		V	
2.39"	+/- .030	2.391"	X		V	
0.50"	+/- .030	0.497"	X		V	
7.500	+/- .010	7.499"	X		V	
2.530"	+/- .010	2.526"	X		V	
1.500	+/- .010	1.499"	X		V	
0.201"	+/- .005	0.201"	X		V	4 Places
(SINK 0.370"	+/- .010	0.362	X		V	

Measured by:	RB / J.S.	Audited by:	S	Prototype Approval:	N/A
Date:	10-10-05	Date:	10/10/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	62565
Description: Bracket	Part Number:	04093-1
Inspection Dwg: 04093-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	J. F. S.	Audited by:	<i>[Signature]</i>	Preliminary Approval:	
Date:	10/10/25	Date:	10-10-25	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10. Oct. 15

Receiving Report

Date: 9/9/02 Batch No: M112067
 Supplier: MAWMA Dart P/O: 10312
 Packing Slip: Yes No
 Invoice: Yes No
 Receipt: Cash Cr
 Release Note Attached: Yes No N/A
 Waybill Attached: Yes No N/A
 Shipment Complete: Yes No N/A
 QC6 Inspection N/A
 Work Order 09/09/02 N/A

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M6061	TGB-200X0400	40	0	0	40	
M6061T	630181X0400	40	0	0	40	
M6061T	TGB1-200X0400	40	0	0	40	

Initials of receiver (if shipment OK) Level 12 CR

M6061T6R0620

Production/Admin:

Date

Received/Costing

Initial

09/09/02

RCR 10312

CY

Location

M 3045126A

64 0 0 64

Currency		Sales Person		Ship Via	F.O.B.	Terms	
CANADIAN DOLLARS		ERYCK BLAIS		NIR:R-557065-1	PREPAID	NET 30 DAYS	
Ln	Back Ordered	Ordered	Unit	Description	Shipped	Price Per	Value
				ALUMINUM FLATS			
		3	PC	AFL 6061 T6 3/4" x 6" x R/L L030012 20' 3 PC/318 LB	3 UN	215.00	645.00
		2	PC	AFL 6061 T6 3/4" x 1" x R/L L026715 20' 2 PC/35 LB	2 UN	36.00	72.00
		3	PC	AFL 6061 T6 1" x 2" x R/L L026407 20' 3 PC/142 LB	3 UN	95.00	285.00
		2	PC	AFL 6061 T6 1/2" x 6" x R/L L027689 20' 2 PC/142 LB	2 UN	145.00	290.00
				ALUMINUM ROUND BAR			
		2	PC	ARB 6061 T6 3/8" x R/L L026602 20' 2 PC/5 LB	2 UN	6.00	12.00
				ALUMINUM SHEET			
		4	PC	ASH 6061 T6 .050" x 48" x 96" L029081 4 PC/92 LB	4 UN	92.00	368.00
		2	PC	ASH 6061 T6 .125" x 48" x 96" L030531 2 PC/115 LB	2 UN	202.00	404.00
				ALUMINUM SQUARE BAR			
		2	PC	ASQ 6061 T6 3/4" x R/L L020464 20' 2 PC/26 LB	2 UN	27.00	54.00
				STAINLESS ROUNDS			
		5	PC	SRB 303 1/2" x R/L L029043 12'1" 5 PC/40 LB	5 UN	18.00	90.00
		7	PC	SRB 303 3/4" x R/L	7 TN	22.00	154.00

Purchase Order Receipt Listing

September 2, 2009 11:34:03 AM

All amounts are calculated in domestic currency.

All Vendors PO ID PO10312 All Receipt Dates All Line Item Types
 All Item ID/GL/WOs All Rec. Employees All Currencies
 Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name	VC-MAG002	Magna Stainless									
PO10312	1	CAD	M6061T6B0.750X06. f 000		9/04/09	9/02/09	60.0000	\$10.75	0.0000	0	\$645.00
		No	6061T6 BAR .750 X f 6.00 112567		60.0000	LAVO01		\$645.00	0.0000	0	
	2		M6061T6B0.750X01. f 000		9/04/09	9/02/09	40.0000	\$3.00	0.0000	0	\$120.00
		No	6061-T6 Bar .750 x f 1.00 112567		24.0000	LAVO01		\$120.00	0.0000	0	
	4		M6061T6B0.750X00. f 750		9/04/09	9/02/09	40.0000	\$1.35	0.0000	0	\$54.00
		No	6061-T6 Bar .750 x f .750 112567		40.0000	LAVO01		\$54.00	0.0000	0	
	5		M6061T6B1.000X02. f 000		9/04/09	9/02/09	60.0000	\$4.75	0.0000	0	\$285.00
		No	6061-T6 Bar 1.00 x f 2.00 112567		60.0000	LAVO01		\$285.00	0.0000	0	
	6		M6061T6B0.500X06. f 000		9/04/09	9/02/09	40.0000	\$7.25	0.0000	0	\$290.00
		No	6061-T6 Bar .500 x f 6.00 112567		40.0000	LAVO01		\$290.00	0.0000	0	
	9		M6061T6R0.375 f 6061-T6 Round Bar f .375"		9/04/09	9/02/09	40.0000	\$0.50	0.0000	0	\$20.00
		No	6061-T6 Round Bar f .375" 112567		24.0000	LAVO01		\$20.00	0.0000	0	
	10		M6061T6S.050 sf 6061-T6 .050 Sheet sf		9/04/09	9/02/09	128.0000	\$2.88	0.0000	0	\$368.00
		No	6061-T6 .050 Sheet sf 112567		128.0000	LAVO01		\$368.00	0.0000	0	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO10312**

Purchase Order Date 9/01/09
PO Print Date 9/01/09

Page Number 1 of 4

Order From :

VC-MAG002

FAXED
9/1/09

MAGNA STAINLESS
5775 RUE KIERAN
ST LAURENT, QC H4S 0A3
CA

Contact Name
Vendor Phone 800 363 6646
Vendor Fax 514 339 1105
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M6061T6B0.750X06.000	6061T6 BAR .750 X 6.00	9/04/09 Yes	✓ 60.00 f	Yours ppd	\$10.7500 <i>10/1/09</i>	\$645.00
2	✓ M6061T6B0.750X01.000	6061-T6 Bar .750 x 1.00	9/04/09 Yes	24.00 f	Yours ppd	\$3.0000 <i>10/1/09</i>	\$72.00
3	M6061T6B0.187X04.000	6061-T6 Bar .178 x 4.00	9/04/09 Yes	40.00 f	Yours ppd	\$1.7500	\$70.00
4	✓ M6061T6B0.750X00.750	6061-T6 Bar .750 x .750	9/04/09 Yes	✓ 40.00 f	Yours ppd	\$1.3500 <i>10/1/09</i>	\$54.00

**MATERIAL CERTIFICATION
REQ'D UPON DELIVERY**

m112567

No substitution or deviation without consent.
Certificate of Conformity or Material Certification required when applicable

Change Nbr: 1

Change Date: 9/01/09

CAN ART
ALUMINUM EXTRUSION INC.

Material Test Report

Customer Ship To:

Magna Stainless Inc.
5775 Kieran St.
St-Laurent
QB H4S 0A3

Our Order: 831165 - 2
Your PO #: PO05960
Part #: 05873-000-240
Die: LS05873
Description: .750 x 6.000
Alloy Temper: 6061 T6
Print Date: 7/31/2009

Chemical Properties

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	others each	others total	Al
0.40-0.8	0.7 max	0.15-40	0.15 max	0.8-1.2	0.04-0.35	0.25 max	0.15	0.05	0.15	remain

Mechanical Properties

Strength ksi

Test ID	Test Date	CastNum	Ultimate	Yield (2% Offset)	Elongation (2" gage length)
1426	7/27/09	09050391A	44.04	40.51	19.5

S
07/09/09

Applicable Specifications: ASTM B221-08 ASTM B308-02 ASTM B429 QQA200/8 QQA200/16

Can Art Aluminum Extrusion Inc. certifies that materials shipped under this order have been inspected and tested in accordance with Aluminum Association and agreed upon customer specifications. Can Art assumes no liability for additional costs which may be incurred during the customer's manufacture and sale of its products, and is subject only to the replacement of any materials not within agreed upon specifications provided written notification is received by Can Art within 30 days from the date of shipment.

Eric Hotte - Tensile Testing

Authorized


Evan Eng, Quality Assurance Mgr.

Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3
 Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

PACKING LIST

I016123

Page: 1 of 2

SOLD TO:
 DART AEROSPACE LTD
 1270 ABERDEEN STREET

HAWKESBURY , ON
 K6A 1K7
 Contact: CHANTAL

SHIP TO:
 DART AEROSPACE LTD
 1270 ABERDEEN STREET

HAWKESBURY , ON
 K6A 1K7
 Ship Terms: PREPAID

SPECIAL INSTRUCTIONS

STOCK

MAGNA
Q.C. 3
MTR.Y

Currency	Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS	ERYCK BLAIS	(613) 632-5200	(613) 632-1053	P010312	
Sales Order	Terms	Ship Via	Date Ordered	Date Required	Date Shipped
W017754	NET 30 DAYS	NIR:R-557065-1	09/01/09	09/02/09	09/02/09

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
3		PC	ALUMINUM FLATS AFL 6061 T6 3/4" x 6" x R/L 20' 318 LB / 3 PC	L030012	09050391A	3
2		PC	AFL 6061 T6 3/4" x 1" x R/L 20' 35 LB / 2 PC	L026715	20296	2
3		PC	AFL 6061 T6 1" x 2" x R/L 20' 142 LB / 3 PC	L026407	6673	3
2		PC	AFL 6061 T6 1/2" x 6" x R/L 20' 142 LB / 2 PC	L027689	09050391A	2
2		PC	ALUMINUM ROUND BAR ARB 6061 T6 3/8" x R/L 20' 5 LB / 2 PC	L026602	45711	2
4		PC	ALUMINUM SHEET ASH 6061 T6 .050" x 48" x 96" 92 LB / 4 PC	L029081	1786831	4
2		PC	ASH 6061 T6 .125" x 48" x 96" 115 LB / 2 PC	L030531	329280101	2
2		PC	ALUMINUM SQUARE BAR ASQ 6061 T6 3/4" x R/L 20' 26 LB / 2 PC	L020464	5716	2

Received by:

Date: 2/09/09

Signature:

Magna Stainless

5775 Kieran St, Saint-Laurent, Québec H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

PACKING LIST

I016123

Page: 2 of 2

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY , ON
K6A 1K7
Contact: CHANTAL

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY , ON
K6A 1K7

Ship Terms: PREPAID

MTR:Y

SPECIAL INSTRUCTIONS

STOCK

Currency	Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS	ERYCK BLAIS	(613) 632-5200	(613) 632-1053	P010312	
Sales Order	Terms	Ship Via	Date Ordered	Date Required	Date Shipped
W017754	NET 30 DAYS	NIR:R-557065-1	09/01/09	09/02/09	09/02/09

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
5		PC	STAINLESS ROUNDS SRB 303 1/2" x R/L	12'1" 40 LB / 5 PC	L029043	422802
7		PC	SRB 303 3/4" x R/L	12'7" 134 LB / 7 PC	L029510	17578
			STAINLESS SHEET			
3		PC	SSH 304 2B 16ga x 48" x 96"	252 LB / 3 PC	L030449	A2800233
6		PC	SSH 304 2B 20ga x 48" x 96"	300 LB / 6 PC	L029414	SC18740
Bundles: 2	Skids: 1			Total Weight:		1,601 LB

Received by:

Lin Gervais

Date: 2/09/09

Signature: